

54491 Derev

Work Order ID 53966



Page 1

November 24, 2009 11:14:41 AM

Item ID: D2873-043
 Revision ID: A
 Item Name: Nut Plate Assembly

Accept



Setup Start



Stop



Start Date: 25/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 07/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

*PT*Date: *09-11-24*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2873

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

*Y.A 09/12/05**20**0*

Jeaspa Bandsaw

Cut blanks: 1.000" x 0.375" x 3.700" long

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

*Y.A 09/12/07**20**0*

HAAS CNC vertical machine #1

Machine as per Folio FA and Dwg D2873 Identify as D2873-3
Dwg Rev *A* Folio Rev *AA*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

*Y.A 09/12/07**20**0*

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53966

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Page 2

Item ID: D2873-043
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Stop



Start Date: 25/11/2009 Start Qty: 20:00



Cust Item ID:

Required Date: 07/12/2009 Req'd Qty: 20:00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00		B.A 09/12/07		20	0		
140 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-Deburr □2- C'sink as per Dwg D2873								
150 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00		2) 5 09/12/08					

Handwritten signature and date: 09/12/08 (20)

Handwritten signature and date: 09/12/08 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53966

November 24, 2009 11:14:42 AM



Page 3

Item ID: D2873-043
Revision ID: A
Item Name: Nut Plate Assembly

Accept



Setup Start



Stop



Start Date: 25/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 07/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		del 02/12/09		20	0		
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		BR 09-12-9		20			
180 Small Fab Small Fab	Small Fab Memo 1-Assemble as per Dwg D2873 □2-Identify as D2873-043	0.00 0.00							

09/12/09 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 24, 2009 11:14:49 AM

Page 1

Work Order ID: 53966

Parent Item: D2873-043RevA

Parent Item Name: Nut Plate Assembly



Comments:

Start Date: 25/11/2009

Required Date: 07/12/2009

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21075L5  Nut Plate		Purchased	No			100	Each	410.0000	60.0000			
				<u>Warehouse</u>	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
				Main Warehouse								
				ST		410						
					110916	79						
					112243	331						
M6061T6B0.375X01.00 0  6061T6 BAR .375 x 1.00		Purchased	No			180	f	17.6095	6.4905			
				<u>Warehouse</u>	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
				Main Warehouse								
				MAT		17.60947368						
					105225	5.3						
					110829	12.3094737						
					113325							

Ep 09/12/09

60

6.1666' N.A 09/12/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 24, 2009 11:14:49 AM

Page 2

Work Order ID: 53966



Parent Item: D2873-043RevA



Parent Item Name: Nut Plate Assembly

Start Date: 25/11/2009

Required Date: 07/12/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD4-6 Rivet		Purchased	No			180	Each	3,930.000	120.0000			

EP 09/12/09

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3930	
100151	27	
103395	14	
105144	88	
110139	3774	
2525	27	

120

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	53964
Description: Radius Block		Part Number:	D2873-3
Inspection Dwg: D2873	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.500	—			
2.000	+/-0.010	2.000	—			
0.750	+/-0.010	.750	—			
1.000	+/-0.010	1.000	✓			
0.250	+/-0.010	.250	✓			
1.000	+/-0.010	1.000	✓			
2.000	+/-0.010	2.000	—			
3.000	+/-0.010	3.000	—			
Ø0.128	+0.005/-0.001	Ø.130	—			
0.359	+/-0.010	.360	✓			
Ø0.316	+0.006/-0.001	Ø.318	—			
1.000	+/-0.010	1.000	✓			
0.250	+/-0.010	.249	—			
0.061	+/-0.010	.064	✓			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	Ø.230 x .125	✓			

Measured by:	<i>[Signature]</i>	Audited by:	H.A	Prototype Approval:	N/A
Date:	09/12/07	Date:	09/12/07	Date:	N/A

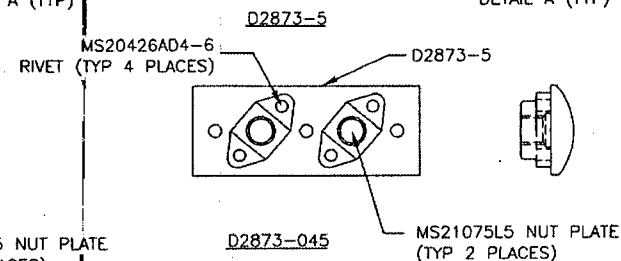
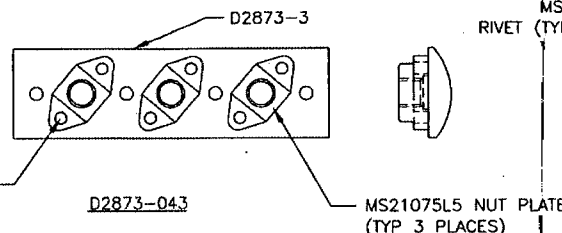
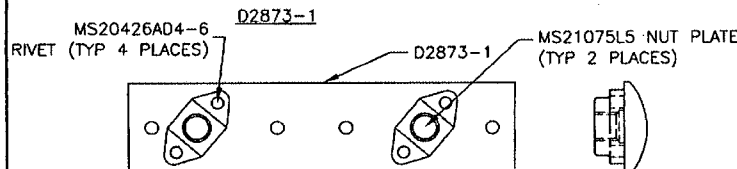
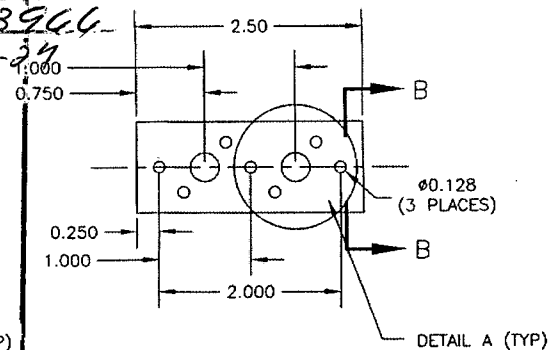
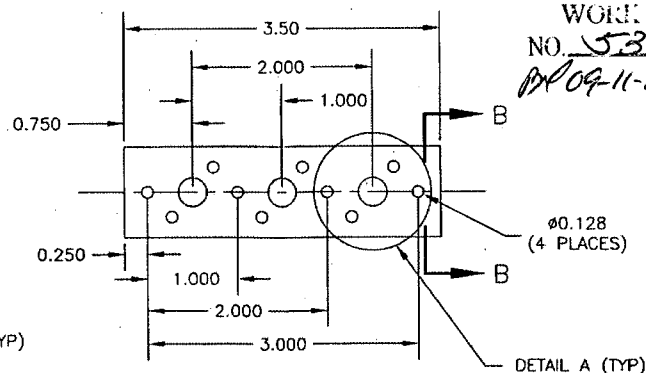
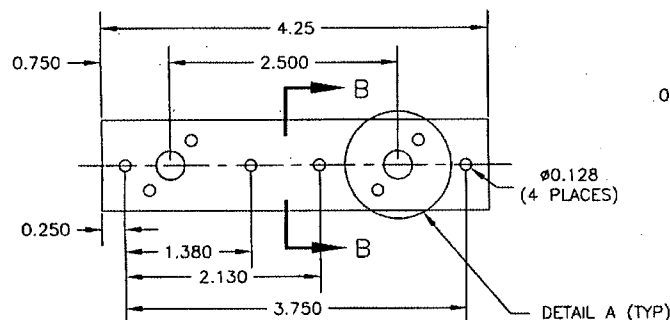
Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	<i>[Signature]</i>

SHOP
RETURN
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT
WORK ORDER

NO. 53966

09-11-24



D2873-041

D2873-043

D2873-045

D2873-1/-3/-5 RADIUS BLOCK

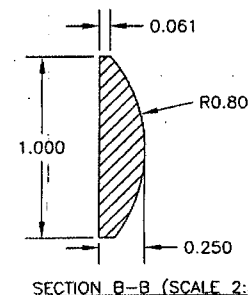
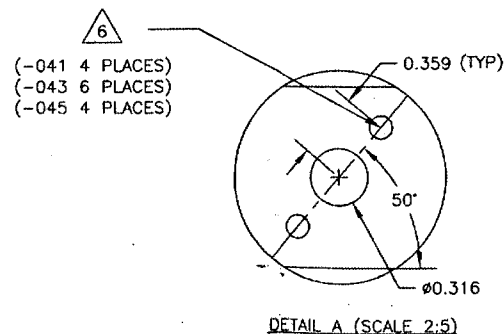
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) 0.128 PILOT + C'BORE CURVED SIDE 0.230X0.125 DEEP + C'SINK CURVED SIDE 0.225 x 100°

D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



RELEASED
05-07-26

A	05.07.26	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED
DATE	05.07.26	TITLE
		RADIUS BLOCK
		SCALE
		4:5